

Date: Friday, 7/21/2006 7:37:02 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE SPACER
 Job Number : 28016
 Estimate Number : 10764
 P.O. Number : *N/A*
 This Issue : 7/21/2006 S.O. No. : *N/A*
 Prsht Rev. : NC Part Number : D2876
 Drawing Number : D2876 REV B
 Project Number : N/A
 Drawing Revision : B
 First Issue : *N/A* Type : MACHINED PARTS
 Material : NOTE:1 BLANK MAKES 4 PARTS
 Previous Run : 26367
 Due Date : 8/20/2006 Qty: 120 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Esr Rev:B 00-05-19 Added inspect level 8 EC
 Est Rev:C Now M6061-T6 06-06-23 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S100 6061-T6 .100 Sheet



Comment: Qty.: 0.0542 sf(s)/Unit Total: 6.5016 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.100" Thick

Batch: ~~116~~ *M 8228*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

SAD 06:08:02

120

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

08:08:02

120

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

[Signature]
06-08-03

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Holes and water jet tabs/mil 06/08/21

Tumble : *debur.*

FF 06-08-15

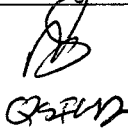

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

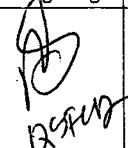
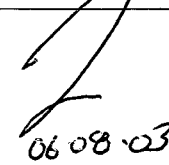

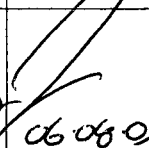


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.m 06-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
060803	5	Add extra for water Jet tabs on the parts to be removed and holes drilled . permanent change	E	06.09.05			 060803

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
060803	2.0	4 parts scrap. deep marks, blown out from the water Jet, at hole locations.		destroy. No replace.	M.F. 06/08/03	 060803		 060803

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06.08.24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 28016

Part Number: D2876

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 06/08/23

(116)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST393

AS 06/08/23

(116)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AS 06.08.24

Job Completion



u 06.08.23

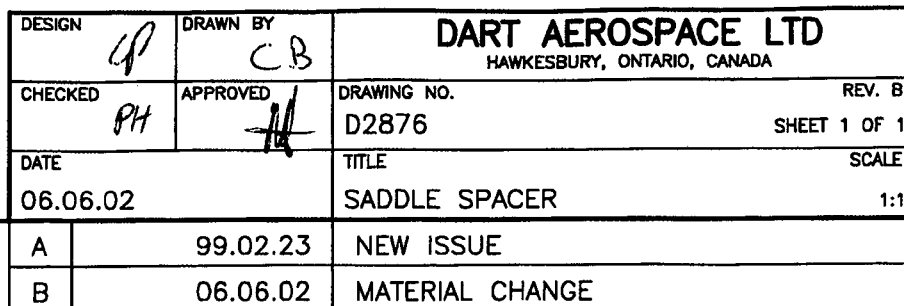
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

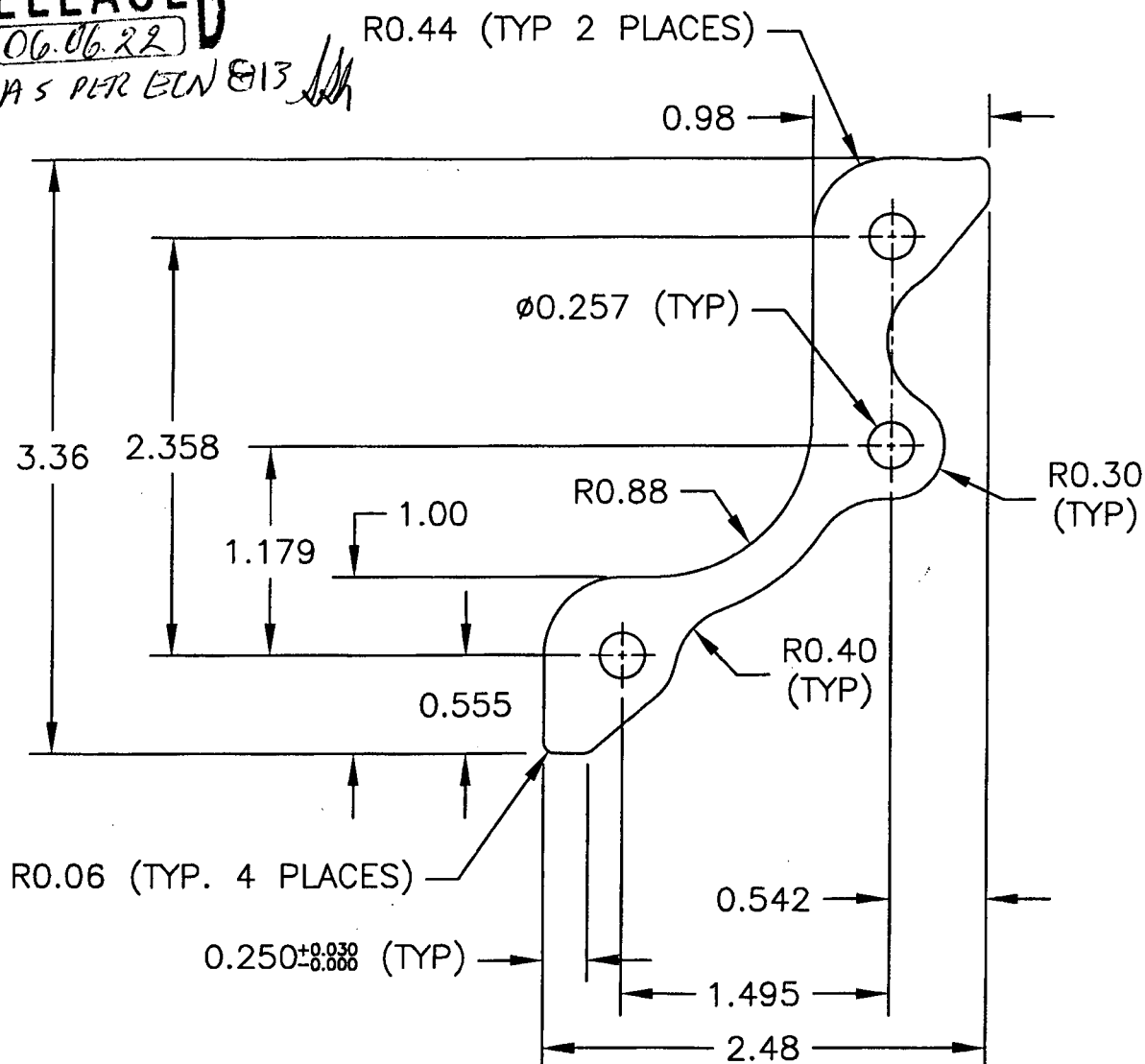
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



AS PER ELN 813



1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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IN CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 28016

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